

Date: Tuesday, 10/30/2007 2:48:35 PM
 User: Kim Johnston

Process Sheet

SPH1T-2

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BLADE		
Job Number	: 35435-2			Part Number	: D2741		
Estimate Number	: 10327			Drawing Number	: D2741 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/30/2007	S.O. No.	:	Drawing Revision	: C		
Prsh Rev.	: NC			Material	:		
First Issue	: 11	Type	: MACHINED PARTS	Due Date	: 11/15/2007	Qty:	30
Previous Run	: 33083			Um:	Each		
Written By	:			30			
Checked & Approved By	:			40			
Comment	: Est Rev: D 00.11.15 Removed P/O turning - in house process EC Est Rev: E 06-03-20 As Per Rev C JLM Est Rev: F 06.04.20 Added grinding after heat treating E C						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M4130NB0500X03000	4130 Bar 0.5 x 3.0"	 101314X4X5 1116294X7X5
Comment: Qty.: 1.2118 f(s)/Unit Total : 48.4722 f(s)		Batch: M105355X33X5	4
.4130 BAR 0.5 x 3.0"			
Material: 4130 steel bar 0.50" x 3.00"			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW			
Cut blanks 13.850" long +0.063" -0.000"			JL 04/12/02
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1			
1-Machine per folio FA108			

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BLADE
Job Number: 35435		Part Number: D2741
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	POWDER COATING	POWDER COATING
		 m106379 30
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		Ex 08/01/17
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 30 30 08-01-17
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
14.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST4166		AS 08/01/18 (30)
15.0	QC21	FINAL INSPECTION/W/O RELEASE
		 A 08-01-21
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 uni 20081121 U

DART AEROSPACE LTD	Work Order:	33435
Description: Blade	Part Number:	D2741
Inspection Dwg: D2741	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

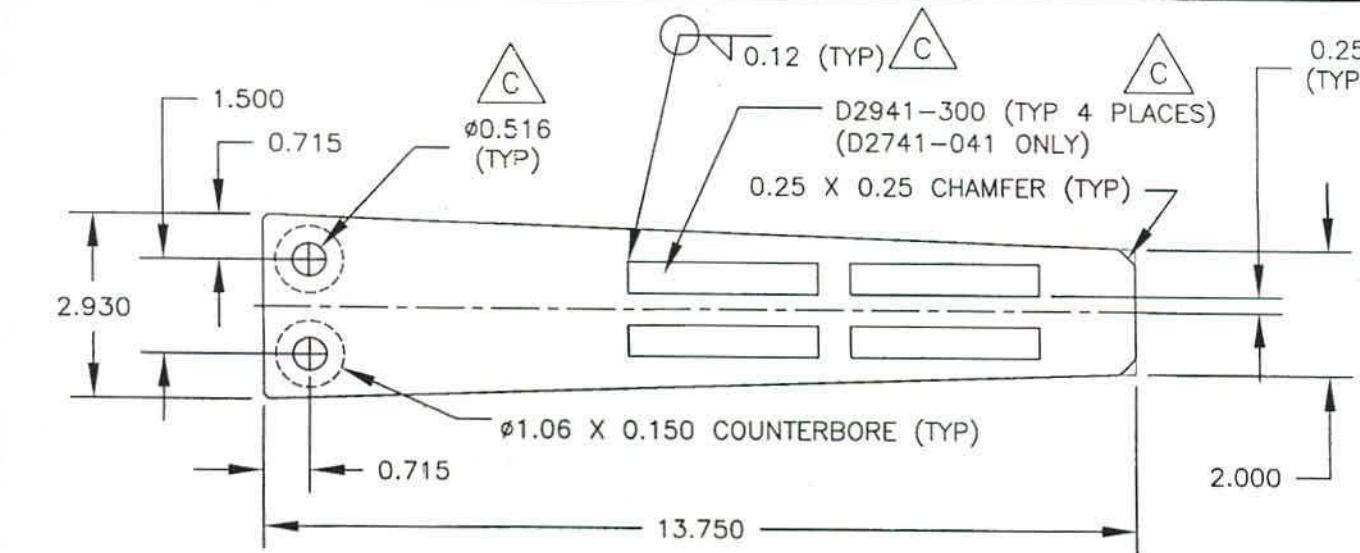
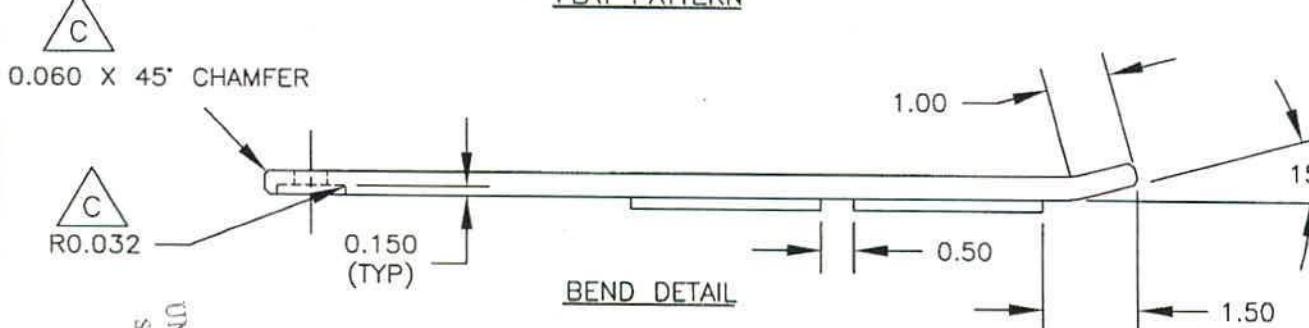
X First Article Prototype

Measured by:	JL	Audited by:	SA	Prototype Approval:	N/A
Date:	07/12/01	Date:	07.12.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	
B	06.03.09	Revised per Rev. C	KJ/JLM	<i>[Signature]</i>

DART**RELEASED**
06.02.07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE		DRAWING NO.	REV. C
<i>PH</i>	<i>PH</i>	D2741	
06.01.12		TITLE	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE C'SINK TO C'BORE	
C	06.01.12	LARGER HOLE, ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS	

FLAT PATTERNBEND DETAIL

WORK ORDER
D2741-041 BLADE
1) MATERIAL: AISI 4130 STEEL 0.375 THICK
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
MIN. YIELD TENSILE STRENGTH = 141 ksi
2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.030 TO 0.060
6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.
REMOVE POWDER COAT FROM SURFACE OF D2941-300
7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE



VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 93756-1

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

01/15/2008

MM/DD/YYYY

PAGE : 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
01/15/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00005193		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2741	B35435 BLADE Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM 100% HARDNESS TESTED PER ASTM E-18 HRC: 34-40 MATERIAL: 4130	EA	40	40	0
02	MC	MINIMUM CHARGE 140 LBS @ \$2.26/LB		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS





RELEASE NOTE

GST No. : R105468102

OAK 93756-1

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1371 SPEERS ROAD, OAKVILLE, ONTARIO
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2009 WYECROFT ROAD, UNIT B
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DATE SHIPPED	SHIP VIA	F.O.B.
01/15/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00005193		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	B35435 BLADE	EA	40	40	<p>Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM 100% HARDNESS TESTED PER ASTM E-18 HRC: 34-40 MATERIAL: 4130</p> <p>100% HARDNESS TESTED 40 pcs. 38/39 HRC</p> <p>OK</p> <p>VAL.O. TH. 25 Q.C.</p>

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Anna Robinson
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
THINNING COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

HEAT
TREATING